

Work Order ID 163389

Tuesday, June 27, 2017 11:36:15 AM

163389

Page 2

Item ID: D5134-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Damper Support Assembly, LH
Start Date: 7/4/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 7/14/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.04				<u>4</u>	<u>0</u>		DAS 45 9-89 2017-7-23
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.08				<u>4</u>	<u>0</u>		DAS 49 9-89 17/07/25
135 *135* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.39				<u>(x4)</u>		<u>2017</u>	<u>BEB</u>

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Required Date: 7/14/2017 Req'd Qty: 4.00 ***4*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
137 *137* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.04				<u>4</u>			DAS 41 9-89 AUG 02 2017
140 *140* SprayPaint Spray Painting	Spray Painting per QSI005 4.2 Memo ***MASK BEARING HOLE AS PER NOTE 2*** PRIME AS PER DWG AND QSI BATCH: <u>137487</u> PAINT AS PER DWG AND QSI BATCH: <u>138220</u>	0.00 2.48				<u>4</u>			DAS 41 9-89 AUG 31 2017
150 *150* QC Quality Control	QC14- Inspect Spray Paint Memo	0.00 0.04				<u>4</u>			DAS 38 9-89 SEP 01 2017

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Revision ID: Stop ***NS2***
Item Name: Damper Support Assembly, LH
Start Date: 7/4/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 7/14/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.40							
Quality Control									

uy

SEP 11 2017

68-2
12
2017

Picklist Print

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Page 1

Work Order ID: 163389

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Parent Item: D5134-041

D5134-041

Parent Item Name: Damper Support Assembly, LH

Start Date: 7/4/2017

Required Date: 7/14/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 14-09-09 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T73B3.000X4.00 0		Purchased	No			100	f	0.5420	0.427	1.797895			

M7075T73B3 000X4 000

7075-T73 Bar 3.0 x 4.0 grain direction along 3"

**

DAS
45
9-89

07-10
07-09

1.8 ft

Location

Loc Qty

Loc Code

MAT

0.542

m136800

(136) 0.542

160

Each

387.0000

2

8

**

DAS
30
9-89

NAS77C6-021

NAS77C6-021

BUSHING

Location

Loc Qty

Loc Code

ST554

387

M134793

137

M134833

250

8

AUG 31 2017

9 Ø0.188 TOOLING HOLE
AS REQUIRED, 2 PL

9 Ø0.257 TOOLING HOLE
AS REQUIRED, 4 PL

0.893
REF

0.36
TYP

R0.063
4 PL

1.932

DART
D5134-041

GRAIN
DIRECTION

0.632
REF

R0.63
Ø0.500^{+0.000}_{-0.001}
THRU

R0.25
THIS EDGE ONLY

0.36
4 PL
0.100
2 PL

0.730

0.632

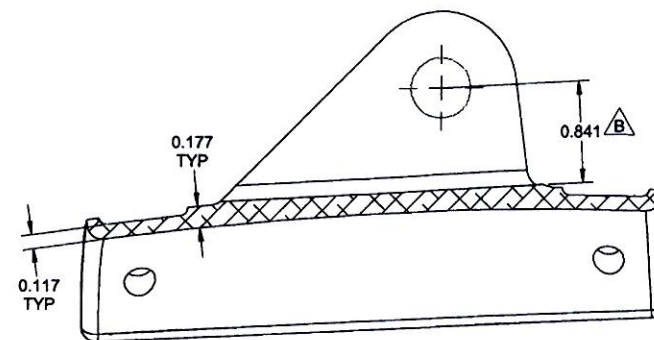
0.728
2 PL

4.671
REF

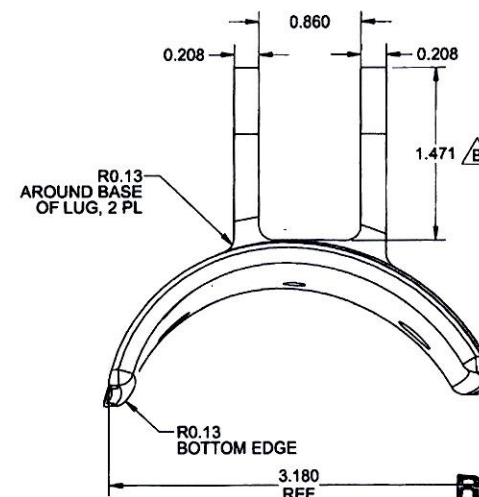
D5134-1 DAMPER SUPPORT, LH

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T73 (T7351 / T73510 / T73511) BAR
PER AMS-QQ-A-200/11 OR AMS-QQ-A-225/9 (AMS 4124) OR
AMS-QQ-A-250/12 (AMS 4078), REF DART SPEC M7075T73B
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART LOGO AND P/N "D5134-041" IN AREA SHOWN
USING 0.125 HIGH X 0.010-0.020 DEEP LETTERING PER DART QSI 044 6.3,
IDENTIFY WITH DART B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.38 lbs
- 8) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D5134-1-REVB.SLDPRT"
- 9) POSITION TOOLING HOLES AS REQUIRED WHILE MAINTAINING MINIMUM 2D EDGE DISTANCE AND 4D PITCH BETWEEN HOLES



SECTION A-A



RELEASED

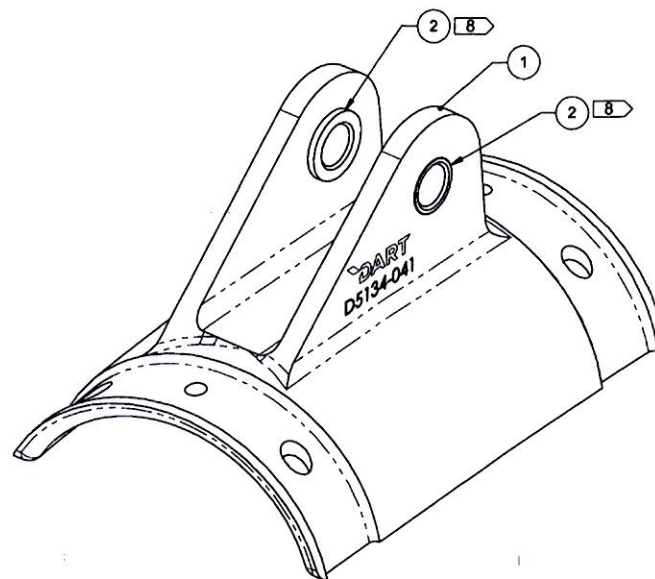
2015 MAY 12
A.R. ECMS-570

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
163389 MS
170703

APPROVED

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP	DRAWING NO.	REV. B
CHECKED	CP	D5134	SHEET 3 OF 4
MFG. APPR.	JLM	TITLE	SCALE
APPROVED	HS	DAMPER SUPPORT ASSY	NTS
DE APPR.	DS	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	15.04.24		

ITEM	QTY	P/N	DESCRIPTION
	X	D5134-041	DAMPER BRACKET ASSY, LH
1	1	D5134-1	DAMPER SUPPORT, LH
2	2	NAS77C6-021	BUSHING



D5134-041 DAMPER SUPPORT ASSY, LH

RELEASED

2015 MAY 12

A.R. Ecnis-520

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME AND PAINT WHITE PER DART QSI 005 4.2
MASK OFF INNER SURFACE OF BUSHING PRIOR TO APPLICATION OF PRIME/PAINT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.42 lbs
- 8) NAS77C6-021 BUSHINGS ARE PRESS FIT INTO D5134-1 DAMPER SUPPORT, IN ORIENTATION SHOWN

B	7075-T73 MATERIAL WAS 7075-T6, MINOR DIMENSIONAL CHANGES (SHT 3 & 4)	AP	15.04.24
A	NEW ISSUE	AP	14.09.02
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	CP	DRAWING NO.	REV. B
MFG. APPR.	JLM	D5134	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	DAMPER SUPPORT ASSY	NTS
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